

Work Order ID 76170

76170

Page 1

Monday, November 07, 2011 12:59:10 PM

Item ID: D3278-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Support Assembly
Start Date: 11/7/2011 Start Qty: 40.00 ***40*** Cust Item ID:
Required Date: 11/16/2011 Req'd Qty: 40.00 ***40*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3278	Rev C								

100 0.00
100 Small Fab
Small Fab Memo 0.00
Small Fab Rivet spacers with support as per Dwg D3278.

ES 11/11/08 (39)

110 0.00
110 QC5- Inspect part completeness to step on W/O
QC Memo 0.00
Quality Control

S. Valos

counted
(39)

120 0.00
120 Small Fab
Small Fab Memo 0.00
Small Fab Assemble support as per Dwg D3278.***DO NOT TIGHTEN
BOLTS***Identify as D3278-041

ES 11/11/10 (39)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		Sulu10		count (x37)			
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <u>481</u> Memo	0.00 0.00				Asst	11/11/14	(38)	
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						11/11/15	MF 11-11-14

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 76170

76170

Parent Item: D3278-041

D3278-041

Parent Item Name: Support Assembly

Start Date: 11/7/2011

Required Date: 11/16/2011

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP: A04.04.19New issueKJ/JLM

IPP B 07.08.21 Chg rivet per PAR185 EC Verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3278-1 *D3278-1* Support		Manufactured	No			100	Each	75.0000	1	40			
**													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				75					
					73412			35					
					74878			40					
D3278-2 *D3278-2* Support		Manufactured	No			100	Each	75.0000	1	40			
**													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				CA				40					
					74879			40					
				GA				35					
					73413			35					
D3278-3 *D3278-3* Spacer		Manufactured	No			100	Each	75.0000	1	40			
**													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				75					
					70984			60					
					73414			15					

W/O:		WORK ORDER CHANGES					
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Work Order ID: 76170

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Parent Item: D3278-041

D3278-041

Parent Item Name: Support Assembly

Start Date: 11/7/2011

Required Date: 11/16/2011

Start Qty: 40.00

Required Qty: 40.00

MS21042L4

Purchased

No

100

Each

12,685.00

2

80

MS21042L4

Nut

**

EP 11/11/10

Location

Loc Qty

Loc Code

ST300

1685

117441

51

117601

532

118451

133

118927

969

ST516

6000

119017

6000

ST518

5000

119075

5000

780

AN4-13A

Purchased

No

120

Each

1,451.000

2

80

AN4-13A

Bolt

**

EP 11/11/10

Location

Loc Qty

Loc Code

ST357

1451

118078

443

118706

8

118838

500

119449

500

780

AN960JD416

NAS1149D0463J

Purchased

No

120

Each

0.0000

4

160

AN960JD416

Washer

**

EP 11/11/10

45 M119097

156x

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Shop Packet Print

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D3278-041

Parent Item Name: Support Assembly

Start Date: 11/7/2011

Required Date: 11/16/2011

Start Qty: 40.00

Required Qty: 40.00

~~X~~ D2230-1
D2230-1
Lug

Manufactured No

120 Each

243.0000

2

80

**

ES 11/11/10

Location

Loc Qty

Loc Code

ST470

94

72811

94

ST476

149

67826

6

70974

3

73398

140

8

70

MS20426AD3-6

Purchased

No

120

Each

3,205.000

4

160

**

ES 11/11/08

MS20426AD3-6

Rivet

Location

Loc Qty

Loc Code

ST316

3205

105055

115

116289

3090

156

W/O:		WORK ORDER CHANGES					
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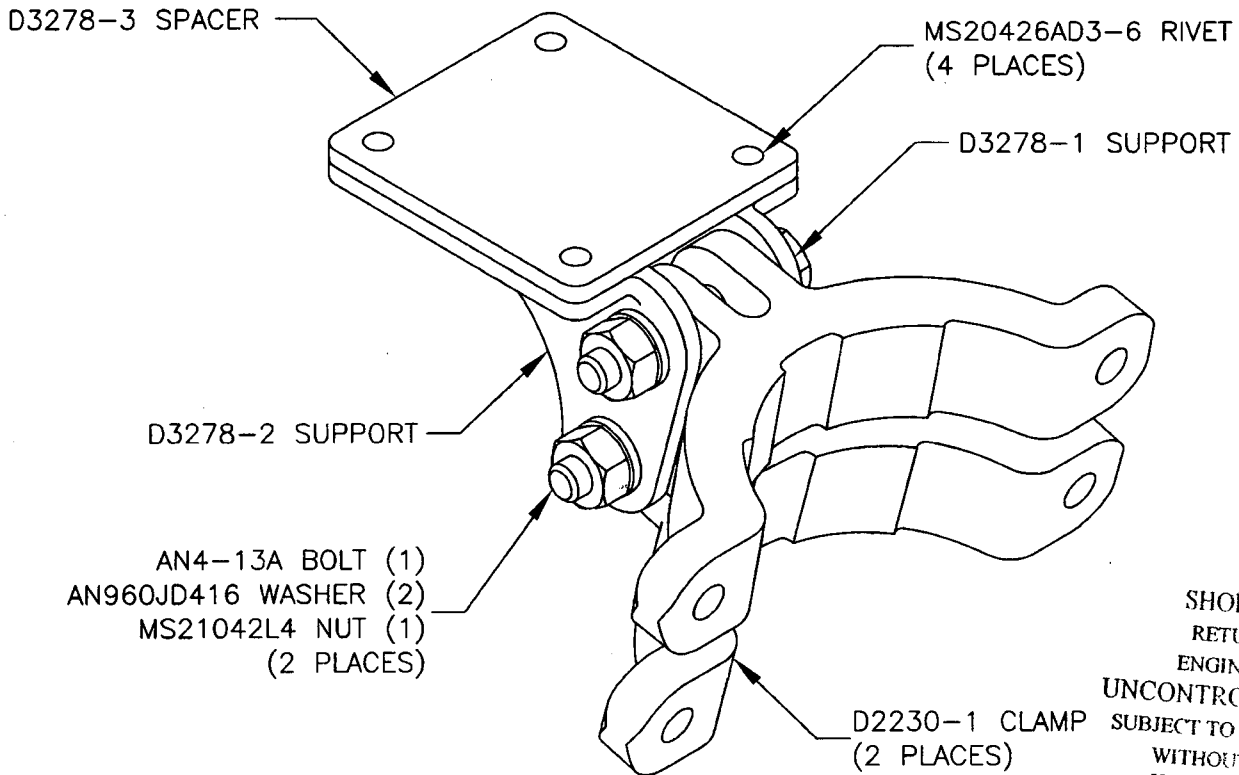
NOTE: Date & initial all entries

DART

DESIGN <i>97</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>13</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07-08-08

D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

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WORK OR FOR
NO. *76120*

10/11/07

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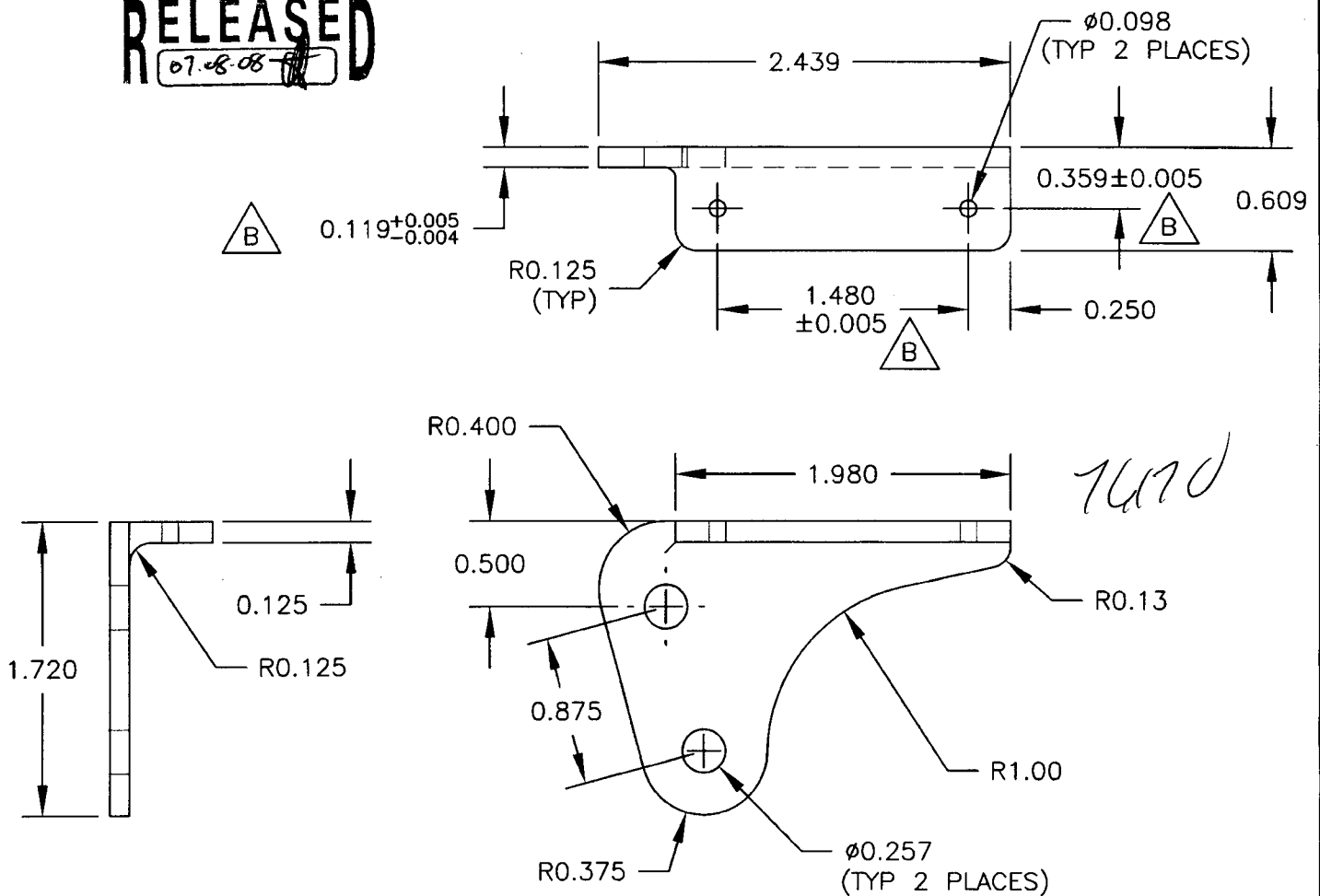
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DESIGN 901	DRAWN BY BC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07-08-08



D3278-1 SUPPORT (SHOWN)

D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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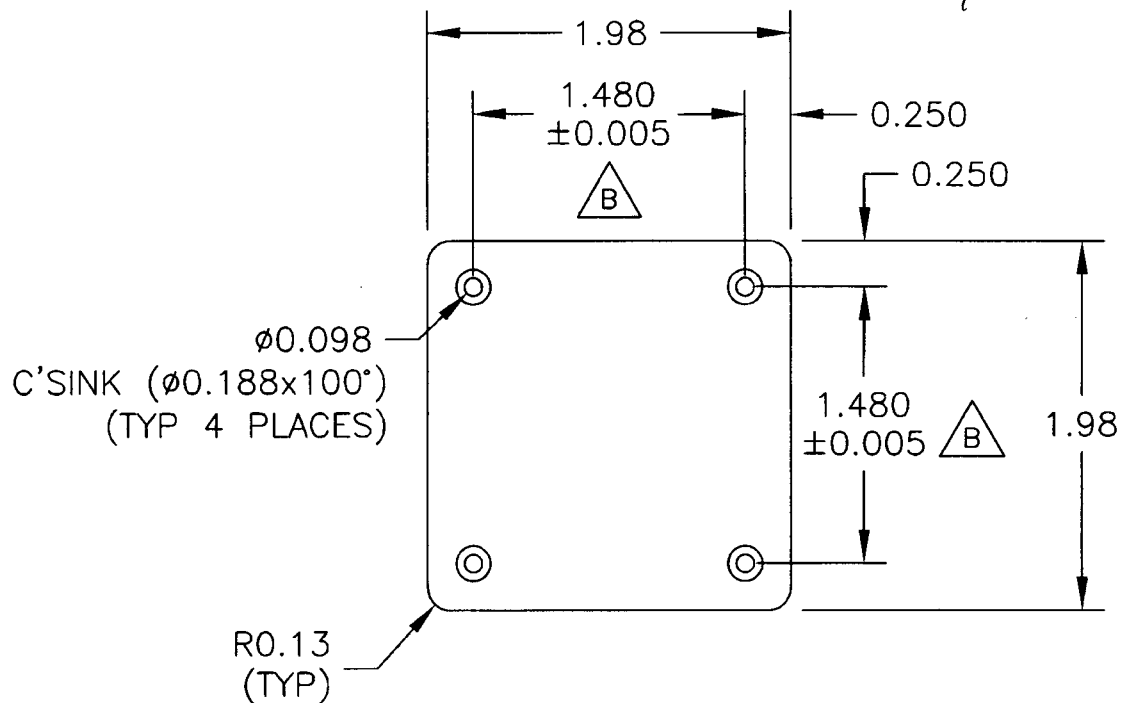
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DART

DESIGN <i>qp</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24	TITLE SUPPORT ASSEMBLY		SCALE 1:1

RELEASED
07.08.08**D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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